

IV.

BREAKOUT SESSION

1. **Altering Surfaces of Previously Accepted Existing Welds** HTC Moore expressed interest in the altering of previously accepted and/or existing service proven welds and the need to perform NDT on those surfaces when altered.

HTC Moore AS-40 - (Group Lead)

HTC Buck COMNAVSURFLANT
HTC Beasley PHNSY Tech Code
HTC Fosdyck PHNSY MT Test Examiner

PURPOSE: There were concerns in regards to the proposed change presented by Mr. Rob Bruins.

DISCUSSION: The Clarification & Proposed Changes to NSTP-271 Working Group's proposed change is to "not" inspect welds that have been previously inspected and accepted providing less than .005" will be removed. The following concerns were noted:

- Who will take that measurement and make that determination?
- When will this measurement be taken? Before or after paint removal.
- How will the measurement be taken?

PROPOSAL: The consensus of the breakout group is that any work that alters the final surface conditions of a weld that was previously accepted should be reinspected.

ACTION: The Breakout Group Lead, HTC Moore, identify & resolve the Breakout group's concerns with the Clarification & Proposed Changes to NSTP-271 Working Group, lead by Mr. Rob Bruins.

ACTION DUE: 31 October 2003

2. SUPSHIP MASTER SOLICITATION CLAUSES (Clause #HQ-C-2-0045)

Considerable discussion on Mr. Simmons group's proposal regarding the simplification of the clause.

Charles Simmons – SUPSHIP Jacksonville (Group Lead)

Bennie Beaver – Independent Consultant, San Diego, CA

Mel Missey – SRF DET Sasebo, Japan

Bryan Reichard – Atlantic Drydock Corp, Jacksonville, FL

Danny Quandt – Northrop Grumman Ship Systems Ingalls, Pascagoula, MS

PURPOSE: Simplify the contract language.

DISCUSSION:

- Combine paragraph A & B of clause HQ C-2-0045 into one paragraph.
- Leave paragraph C as is.
- Remove references to ASNT SNT-TC-1A since the TP-271 invokes this document.
- Eliminate the definition of first tier subcontractor. We want this clause to apply to any subcontractor not just first tier. Many subcontractors are subcontracting services as well.
- We do not find it necessary to designate a revision of the TP-271. When the contract is issued, the NAVSEA standard item applicable to that contract is designated. The NAVSEA standard items designate the 271 revision required.

PROPOSAL: Make the following change to clause HQ C-2-0045:

- The Contractor and any Nondestructive Testing (NDT) subcontractor shall utilize for the performance of required NDT, only Level I, II, and III personnel currently certified in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271. Documentation pertaining to the qualification and certification of NDT personnel shall be made available to the Contracting Officer for review upon request.
- Paragraph (C) will become paragraph (B).

ACTION:

- The Breakout Group Lead, Mr. Charles Simmons, submit proposed change to NAVSEA 04XQ, Mr. David Beck @ beckdm@navsea.navy.mil, with copy to Mr. Flaherty NAVSEA 04XQ1R. ACTION DUE: 31 October 2003.
- SUPSHIP Jacksonville ensure NDT working group is updated at the 2004 conference; action item 03-02.

3. STANDARDIZED SUPSHIP WRITTEN PRACTICE AND LEVEL II WRITTEN EXAMINATIONS

Group Leads

Mr. Frank Wagner, POC Examinations: SUPSHIP San Diego

Mr. James "Wayne" Rougeau, POC Written Practice: SUPSHIP New Orleans

Don Herring – SUPSHIP Bath

Jeff Jacobs – SUPSHIP Bath

Dale Apicelli – SUPSHIP Groton

Doreen Kahue – Recorder: SUPSHIP San Diego, DET Pearl Harbor

PURPOSE: To standardize the written practices and Level II written examinations throughout the SUPSHIP activities of the Navy.

DISCUSSION: General discussion took place as to how best to develop a standardized SUPSHIP written practice and level II written examinations.

PROPOSALS & ACTIONS DUE:

Written Examinations:

- Mr. Wagner will send the committee members a copy of his presentation – ASAP (side note the presentation will also be available through the SUPSHIP QA webmaster)
- Committee members to submit proposed VT, MT and PT examination questions for theory and specifics to Mr. Wagner no later than September 1, 2003.
- Mr. Wagner will determine the test generating type program to be utilized no later than November 2003.
- A draft test bank of examination questions will be forward to a review group. The review group will comprise of only SUPSHIP Level III's qualified in that method (e.g., the MT exam bank will only be reviewed by a NAVSEA certified MT Level III). To prevent compromising the draft test bank, all review group members should maintain exams in a secure environment/facility. **ACTION DUE:** February 2004.

Written Practice:

- Wayne Rougeau will send "draft" written practice including standardized forms to the committee for review and comments.
- Committee members will review and comment on the "draft" written practice no later than 60 day from date of receipt. **ACTION DUE:** 31 October 2003

4. P- 80 BELLED-END FITTINGS REFERENCE MARKS

Don Herring – SUPSHIP Bath (Group Lead)

Wayne Rougeau – SUPSHIP New Orleans

Jeff Jacobs – SUPSHIP Bath

Dale Apicelli – SUPSHIP Groton

Frank Wagner – SUPSHIP San Diego

Doreen Kahue – SUPSHIP, San Diego DET Pearl Harbor

Jack Laws – Quality Inspections

Jack Capri – INTRA-SPECT

Gene Christmas – Honolulu Shipyard Inc.

PURPOSE: Evaluate the best practice to determine weld size for NAVSEA Technical Publication S9074-AR-GIB-010/278 (TP-278), P-2 (socket) type welds.

DISCUSSION: Currently P-2 fillet welds require a weld size of 1 x 1 3/4T. TP-278 requires a reference mark for P-1 weld joints to as an aid in verifying weld size. TP-278 does not require a reference mark for P-2. The group concluded that there was no consistent way to determine welds size without a physical reference point.

PROPOSAL: Add wording to TP-278 to require reference marking of P-2 type joints, as is required for P-1 joints.

ACTION:

- Don Herring will write changes for review and chop. Chop should include all public Naval Shipyards, including from the private sector. Mr. Flaherty will provide Mr. Herring with Shipyard POCs and assist in private sector POCs. **ACTION DUE:** 31 October 2003
- Final change request will be forwarded to Mr. Flaherty on the TP-278 Standardization Document Improvement Proposal form for submittal. **ACTION DUE:** 31 October 2003

5. EDDY CURRENT WELD SURVEILLANCE

Dennis Coffey – PNS (Group Lead)

Joe Brown – PHNS & IMF

Ronnie Rude – PSNS

Rob Bruins – NAVIMFAC PACNORWEST

Gary Pond – TRF Kings Bay

Russ Kok – NAVSEA 05ME

PURPOSE: Establish best practice

DISCUSSION / PROPOSALS:

- Standardize Material: Steel is steel.
- Surface Prep: No prep required except to allow free movement of the probe. Weld Splatter should be removed.
- Scanning Speed: Discussed limiting scanning speed to the speed used to verify notch. No action required.
- Two (2) Man Teams: Leave up to each activity to determine.
- Instruments: Amlec to be phased out. Use of X-Y Storage instrument type not critical.
- Probes: Manufacturer and frequency not critical, but can be the result of difference between activities. Recommend the use of similar coil size, probe radius and probe type.
- Frequency: To be determined by the activity dependent upon equipment and application. All activities to look at using 200 kHz as a starting point.
- Performance Verification Block: **Recommend change** – Changing TP-271 to allow use of a flat plate reference block since welded standards cannot be made consistently.
- Paint Thickness: Discussion included: 1) Allowing the use of any non-conductive material or alternate techniques to be used to compensate for paint thickness on the weld. 2) What techniques to use when indications are found (i.e., verify coating thickness at location of indication, other compensation techniques and recalibration) to determine if MT inspection is needed.
- Verification Block Notch Size: **Recommend change** – notch depth to .030" to represent allowable undercut depth. Notch at .030" depth produces eddy current signal approximately double the amplitude of the current .015" notch which would greatly reduce the number of non-relevant overcalls.

ACTION:

- The Breakout Group Lead, Mr. Dennis Coffey, will write changes for review and chop. Chop should include all public Naval Shipyards. ACTION DUE: 30 September 2003
- Mr. Coffey submits recommended changes to the Clarification & Proposed Changes to NSTP-271 Working Group, lead by Mr. Rob Bruins. ACTION DUE: 31 November 2003

5. **EDDY CURRENT WELD SURVEILLANCE cont.**

- Mr. Rob Bruins submits recommended changes to NAVSEA 05ME. ACTION DUE: 31 December 2003
- Joe Brown to provide Russ Kok with data about amplitudes of ET signals on last side passage inspection, particularly for indications from cracks. ACTION DUE: 30 September 2003
- PNS provide feedback to next year's working group.

6. **UNDERWATER NDT LEVEL III RESPONSIBILITIES**

Joe Curtis – PSNS (Group Lead)

Keith Taylor – NSWCCD-SSES

Bill Loud – SIMA, San Diego

Richard E. Parker - NSWCCD-SSES

Jim Fenner – NAVSEA 00C53

Dave Homen – SIMA, San Diego

PURPOSE: Determine requirements to turnover of Underwater (UW) Level III certification and oversight responsibilities . Determine who will assume the responsibilities for UW Level III certification and oversight. Discuss program changes needed to support UW welding and inspection in both Navy and civilian programs

DISCUSSION: The following items were brought up for discussion:

- Turnover of Level III Program responsibilities to Mr. Keith Taylor. A process has been established for that turnover.
- Extent of responsibilities associated with the Level III Program.
- Certification and Functional Audits of Activities.
- Certification and/or Qualifications of Navy and Civilian program Level III's and sequencing of training, certification, and oversight.
- Use of third (3rd) party oversight on welding NDT jobs and how it relates to periodic audits.
- Civilian program requirements with regards to qualifications or certifications of Level III personnel.
- Designated training site for Level III candidates.

ACTION:

- Mr. Curtis will turn program over to Mr. Taylor. ACTION DUE: 31 July 2003. The process will include Mr. Taylor traveling to Puget Sound Naval Shipyard to review and receive all records.

6. **UNDERWATER NDT LEVEL III RESPONSIBILITIES cont.**

- A visit to San Diego to certify HTC Loud of SIMA, San Diego. This will serve as both a licensing evolution for Mr. Taylor and providing a service for SIMA, San Diego. Mr. Taylor will provide Mr. Flaherty with a letter of intent to assume duties and will include a work history and a short resume. Mr. Taylor to provide Mr. Flaherty a Letter of Intent and Resume. ACTION COMPLETE: 18 June 2003
- Mr. Flaherty designates Mr. Taylor as the UW Level III certification agent upon completion of turnover.
- Revise Chapter 7 of the PRO-070 manual. ACTION DUE: 30 September 2003.
- Solicitations for input to change will be provided by Mr. Fenner to working group. The working group will feed back proposed changes. ACTION DUE: 31 December 2003.
- Publish 074 VI Rev 5. This revision contains items that are relevant to the UW Weld NDT program and need to be published. ACTION DUE: 31 December 2003.